

Work Order ID 99859

99859

PRELIMINARY ISSUE

Page 1

Friday, April 12, 2013 7:14:22 AM

Item ID: D4787-1

Accept

N900040100

Setup Start *NS1*

Revision ID: PRELIM

Item Name: Fwd Bracket

Stop *NS2*

Start Date: 4/12/2013 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/12/2013 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4787

PA3

110

0.00

110

Waterjet

FLOW CNC Waterjet

301 1/4 HARD .125"

Memo

1-Cut as per Dwg

Dwg Rev: PA3

Prog Rev: PA3

2-Deburr if necessary

0.00

2 0 Jm 13-4-12

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

2 0 Jm 13-4-12

Work Order ID 99859

99859

Page 2

Friday, April 12, 2013 7:14:22 AM

Item ID: D4787-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: PRELIM
 Item Name: Fwd Bracket Stop ***NS2***
 Start Date: 4/12/2013 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 4/12/2013 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	Memo	0.00 0.00				2			
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <i>Robert</i> Memo	0.00 0.00				u			
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							u 1304-12

POSITIVE RECALL
 EFFECTIVE 1304-12 AUTH u
 RELEASED _____ DATE _____

Picklis. Print

Friday, April 12, 2013 7:14:19 AM

Page 1

Work Order ID: 99859

Parent Item: D4787-1

Parent Item Name: Fwd Bracket

Start Date: 4/12/2013

Required Date: 4/12/2013

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE13-03-29 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M301S11GA

Purchased

No

sf

24.0000

12863158

1.5

JmB-4-12

301 SS Sheet - 1/4 hard .125

Location

Loc Qty

Loc Code

ST

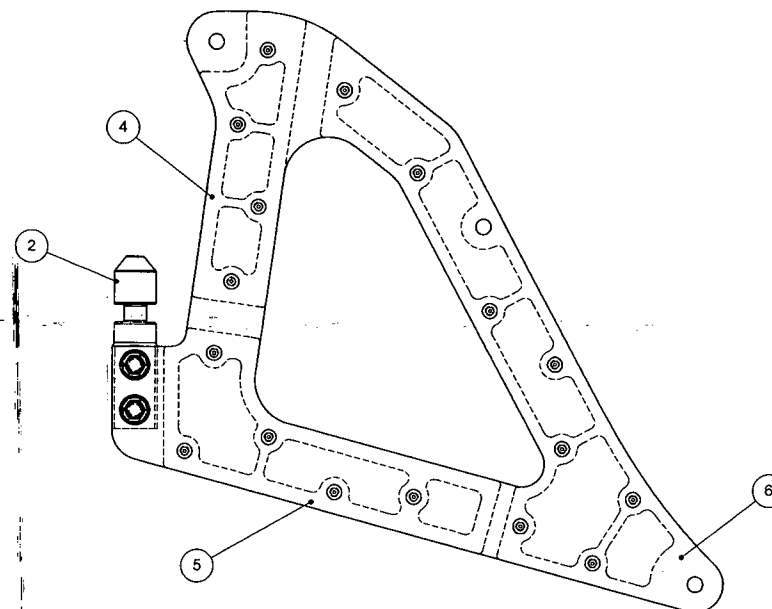
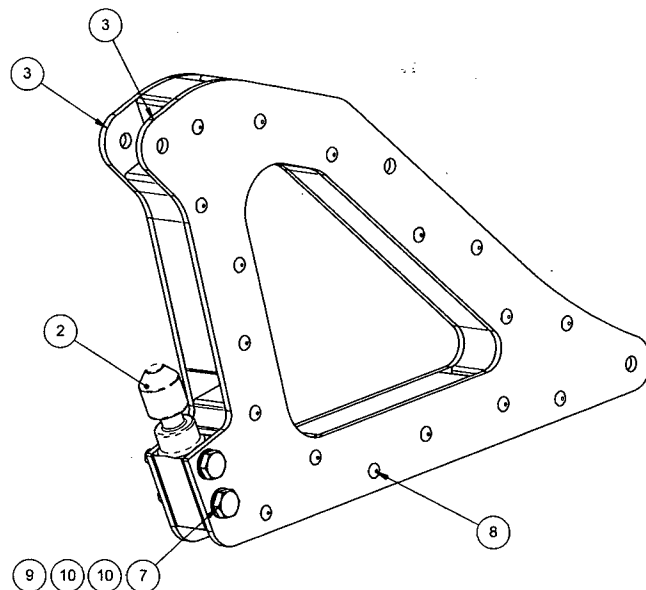
24

125267

24

125267

ITEM NO.	QTY. .041	PART NUMBER	DESCRIPTION
1	x	D4787-041	FWD BRACKET ASSEMBLY
2	1	D4149-5	EYEBOLT STUD
3	2	D4787-1	BRACKET
4	1	D4787-3	FWD SPACER
5	1	D4787-5	FWD SPACER
6	1	D4787-7	FWD SPACER
7	2	AN4C13A	BOLT
8	17	MS20615-4M18	RIVET (MONEL)
9	2	MS21043-4	NUT
10	4	NAS1149C0432R	WASHER



99859

D4787-041 FWD BRACKET ASSEMBLY

PRELIMINARY ISSUE

13.03.02

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.14 lbs

PA3	NEW ISSUE	RF	13.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	DC		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.03.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. PA3

D4787 SHEET 1 OF 5

TITLE SCALE

FWD BRACKET ASSEMBLY NTS

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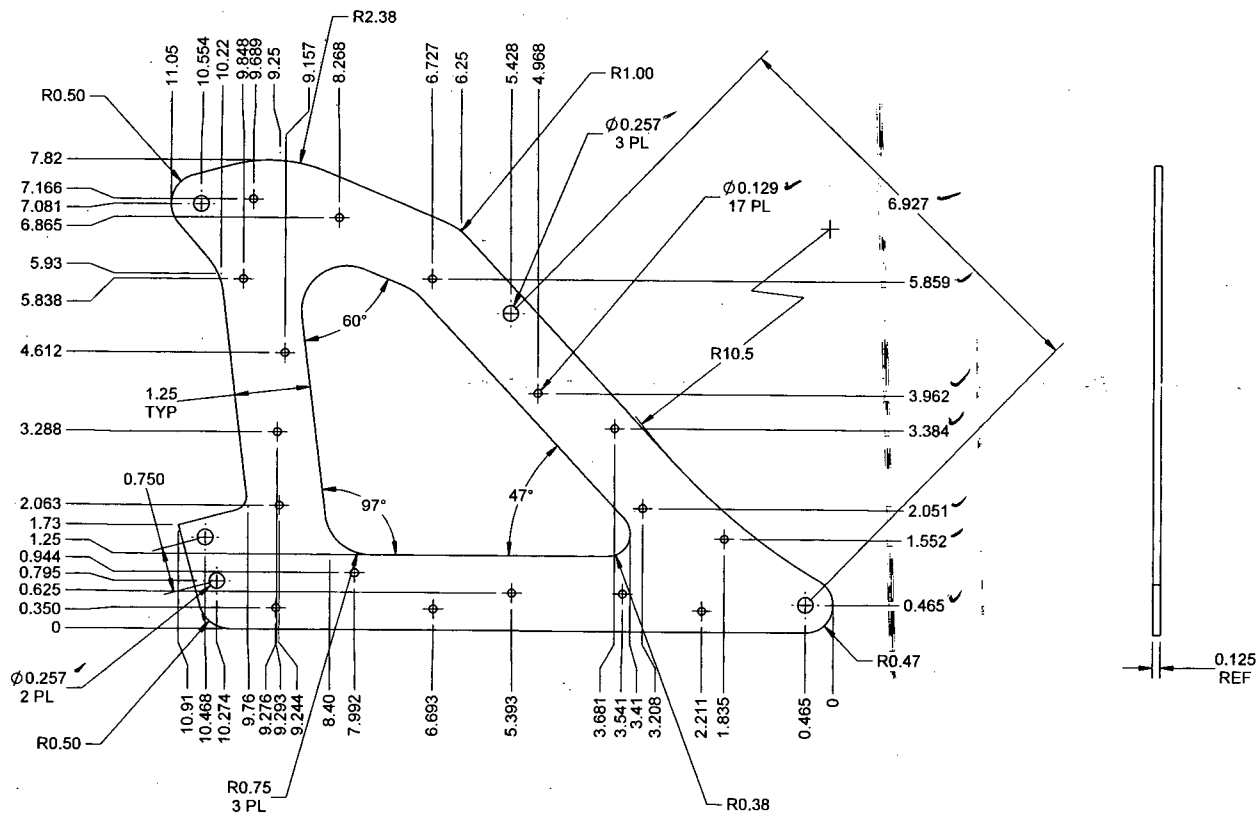
8 7 6 5 4 3 2 1

D

C

B

A



D4787-1 BRACKET

PRELIMINARY ISSUE

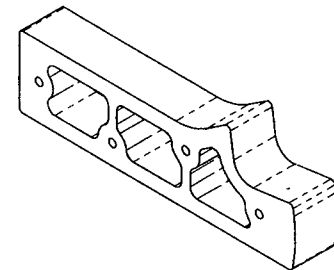
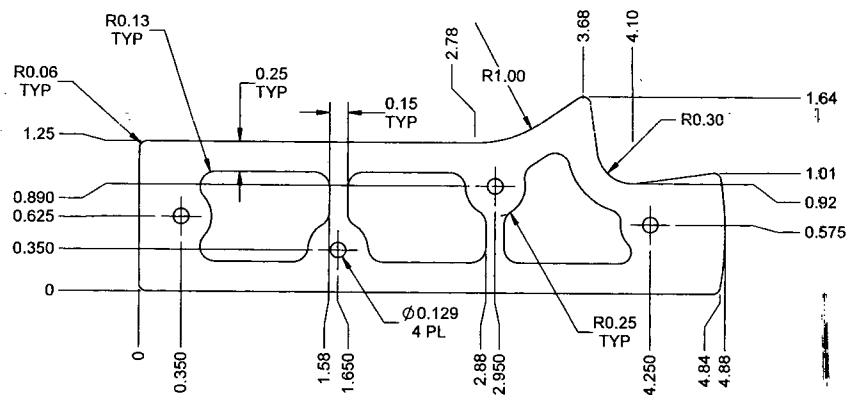
13.03.02

NOTES:

- 1) MATERIAL: AISI 301 STAINLESS STEEL SHEET 2B, 0.125 THK
MINIMUM 1/4 HARDNESS
PER AMS 5517/5518/5902/5519 OR ASTM A666
MIN. Ft_u = 125 Ksi & MIN. Ft_y = 75 Ksi
REF DART SPEC M301S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.26 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D4787	REV. PA3 SHEET 2 OF 5
MFG. APPR.		TITLE FWD BRACKET ASSEMBLY	SCALE NTS
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DATE	13.03.02		

8 7 6 5 4 3 2 1



D4787-3 FWD SPACER

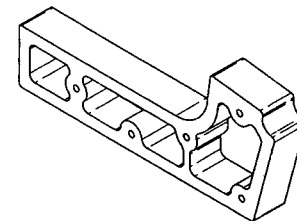
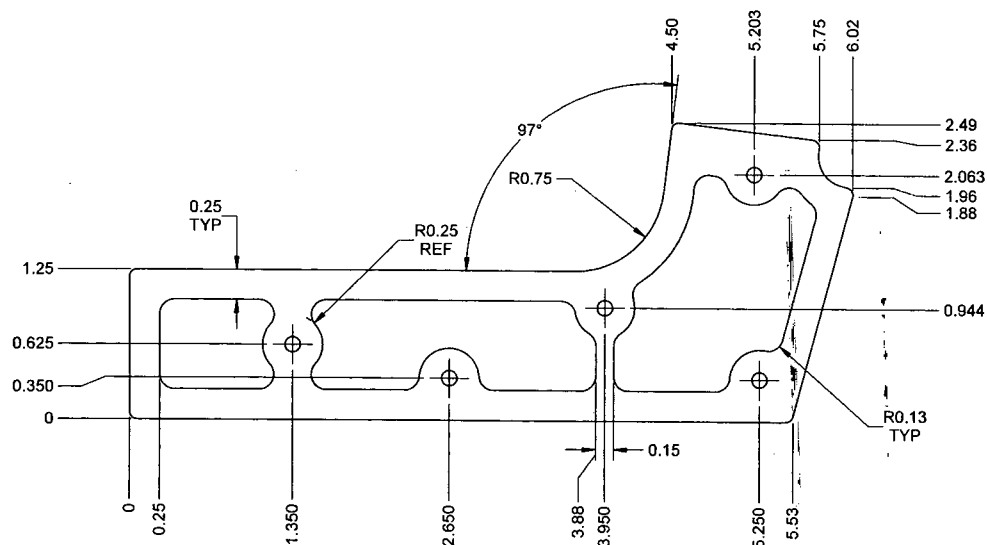
NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

PRELIMINARY ISSUE

13.03.02

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D4787	REV. PA3
MFG. APPR.			SHEET 3 OF 5
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D4787-5 FWD SPACER

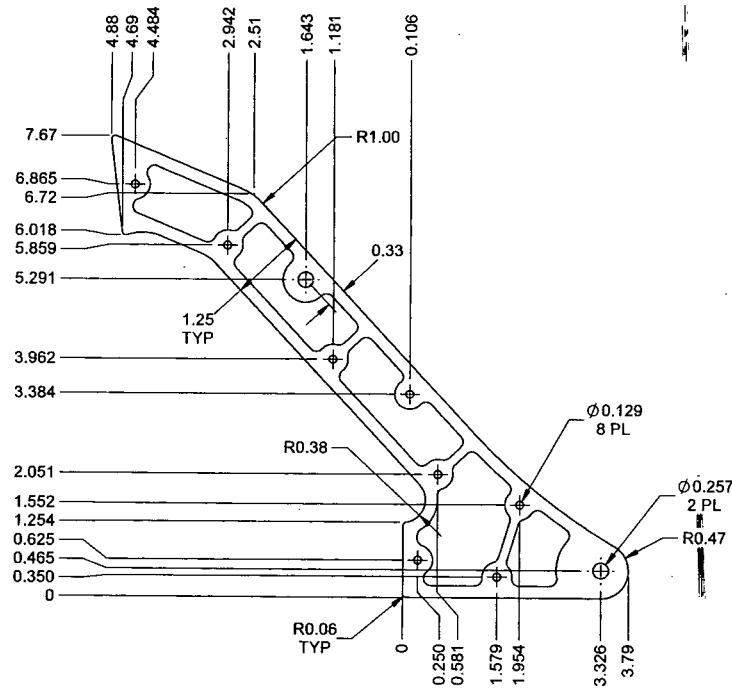
PRELIMINARY ISSUE

RF 13.03.02

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D4787	REV. PA3 SHEET 4 OF 5
MFG. APPR.		TITLE FWD BRACKET ASSEMBLY	SCALE NTS
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DE APPR.			
DATE	13.03.02		



D4787-7 FWD SPACER

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.55 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D4787	REV. PA3
MFG. APPR.			SHEET 5 OF 5
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DART AEROSPACE LTD		Work Order:	99659
Description: Bracket		Part Number:	D4787-1
Inspection Dwg: D4787 Rev: PA3		Page 1 of 1 1 of 3	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.129"	+0.005 -0.001	0.132"	-		✓	Jlmo
Ø 0.253"	+0.006 -0.001	0.259"	-		✓	
0.465"	+0.010	0.468"	-		✓	
1.552"	+/- 0.010	1.556"	-		✓	
2.051"	+/- 0.010	2.056"	-		✓	
3.384"	+/- 0.010"	3.387"	-		✓	
3.962"	+/- 0.010	3.966"	-		✓	
5.859"	+/- 0.010	5.862"	-		✓	
6.923"	+/- 0.010	6.930"	-		✓	
0.465"	+/- 0.010	0.468"	-		✓	
1.835"	+/- 0.010	1.835"	-		✓	
2.211"	+/- 0.010	2.215"	-		✓	
3.208"	+/- 0.010	3.212"	-		✓	
3.41"	+/- 0.030	3.41"	-		✓	
3.541"	+/- 0.010	3.544"	-		✓	
3.681"	+/- 0.010	3.690"	-		✓	
5.393"	+/- 0.010	5.397"	-		✓	
6.693"	+/- 0.010	6.698"	-		✓	
7.992"	+/- 0.010	7.998"	-		✓	
8.40"	+/- 0.030	8.402"	-		✓	Prod WJ02
9.244"	+/- 0.010	9.247"	-		✓	
9.293"	+/- 0.010	9.297"	-		✓	
9.276"	+/- 0.010	9.274"	-		✓	

Measured by: JH	Audited by:	Preliminary Approval:
Date: 13-4-12	Date:	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD		Work Order: 99859
Description: Bracket		Part Number: 04787-1
Inspection Dwg: D176A Rev: PA3		Page 1 of 1 2 of 3

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.76"	+/-0.030	9.765"	-		✓	
10.274"	+/-0.010	10.275"	-		✓	
10.468"	+/-0.010	10.467"	-		✓	
10.91"	+/-0.030	10.919"	-		✓	
0.350"	+/-0.010	0.353"	-		✓	
0.625"	+/-0.010	0.630"	-		✓	
0.795"	+/-0.010	0.799"	-		✓	
0.944"	+/-0.010	0.943"	-		✓	
1.25"	+/-0.030	1.261"	-		✓	
1.73"	+/-0.030	1.73"	-		✓	
2.063"	+/-0.010	2.066"	-		✓	
3.288"	+/-0.010	3.292"	-		✓	
4.612"	+/-0.010	4.619"	-		✓	
5.838"	+/-0.010	5.844"	-		✓	
5.93"	+/-0.030	5.93"	-		✓	
6.865"	+/-0.010	6.867"	-		✓	
7.081"	+/-0.010	7.088"	-		✓	
7.166"	+/-0.010	7.164"	-		✓	
7.82"	+/-0.030	7.82"	-		✓	
4.968"	+/-0.010	4.974"	-		✓	
5.428"	+/-0.010	5.433"	-		✓	
6.25"	+/-0.030	6.25"	-		✓	
6.723"	+/-0.010	6.732"	-		✓	

Measured by: JM	Audited by: ^{DAJ} 27	Preliminary Approval:
Date: 13-4-12	Date: 13-4-12	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

